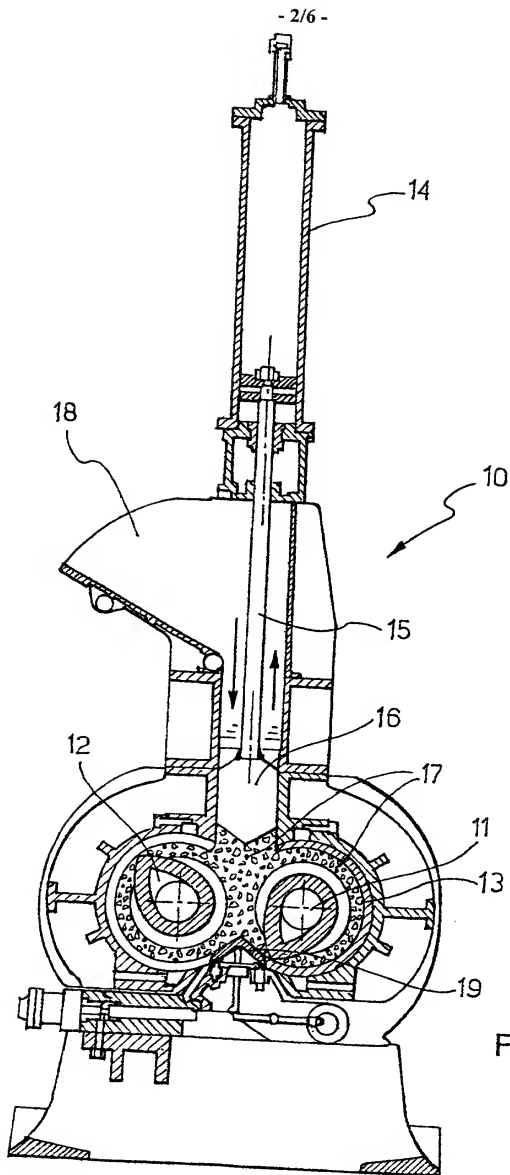


FIG.1



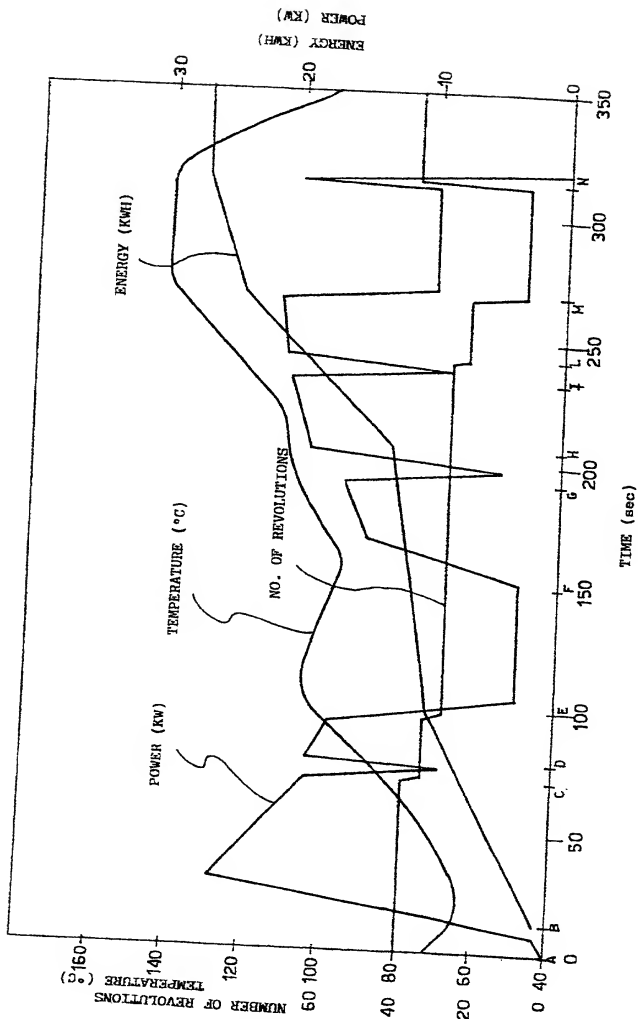


FIG. 3

PROCESS PARAMETERS	EXPECTED PROCESS PARAMETERS AND ASSOCIATED TOLERANCES				NON-CONFORMANCE BY WEIGHT				EXAMPLE OF CHECK FOR COMPLIANCE OF PROCESS PARAMETERS WITH A BATCH WITH PREDEFINED LIMIT-VALUES				BASIS: TOTAL SCORE
	MIXTURE				MIXTURE				MIXTURE				
	STEP NO.	Set value	Tol.-	Tol.+	WEIGHT	STEP NO.	ACTUAL VALUE WITHIN LIMITS?	SCORE	STEP NO.	ACTUAL VALUE WITHIN LIMITS?	SCORE		
STEP TIME (sec)	H-I	30	0	6	5	H-I	48 sec	NO	H-I	48 sec	NO	5	0-2 : NORMAL
PARTIAL TEMPERATURE (°C)	I	120	0	5	5	I	120 °C	YES	I	120 °C	YES	0	
PARTIAL ENERGY (KWH)	I	17.5	1.5	1.5	5	I	19.7 KWH	NO	I	19.7 KWH	NO	5	
STEP TIME (sec)	L-M	25	5	5	7	L-M	42 sec	NO	L-M	42 sec	NO	7	21-30: DEFECTIVE 1st DEGREE
PARTIAL TEMPERATURE (°C)	M	145	0	0	0	M	145 °C	YES	M	145 °C	YES	0	
PARTIAL ENERGY (KWH)	M	24.5	2.4	2.4	8	M	27.7 KWH	NO	M	27.7 KWH	NO	8	
PARTIAL CYCLE TIME (sec)	N	315	45	125	10	N	470	NO	N	470	NO	10	31-60: DEFECTIVE 2nd DEGREE
TOTAL MIXING TIME (sec)	N	245	25	120	40	N	308	YES	N	308	YES	0	
TOTAL ENERGY (KWH)	N	27.0	1.0	4.0	10	N	32.1	NO	N	32.1	NO	10	
PARTIAL TEMPERATURE (°C)	N	145	4	4	10	N	144	YES	N	144	YES	0	> 60 : REJECT
					100							45	DEFECTIVE 2nd DEGREE

Fig.4

REFERENCE CLASSIFICATION	
≤ 6 min	NORMAL
> 6 min / 9 min	DEFECTIVE 2 nd DEGREE
> 9 min	REJECT

PROCESS PARAMETERS	DETECTED VALUE
MAINTENANCE TIME OF MIXTURE INSIDE THE EXTRUDER	11 min

▲ REJECT

FIG. 5

Fig. 6

